

MUST SHIP MONDAY OCT 3

Work Order ID 74552

Friday, September 30, 2011 1:16:59 PM

Page 1

Item ID: D3256-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Panel

Start Date: 9/30/2011 Start Qty: 1.00

Required Date: 10/3/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3256

Rev C + HAND CHARGE

SEE HAZ W/ EAL SWEET,

1.09.30

0.00

100



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3256

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

11-10-3

①

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

11-10-3

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

- inspectors only to RUC
Dry with Hand charges
Outlets. (F)

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Start Date: 9/30/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/3/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start



QC: Date:

SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	NC BRAKE	0.00							
Brake NC	Memo	0.00							
Brake NC	Form using D3256-1T2								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
150 	Identify as per dwg & Stock Location: <u>176</u>	0.00							
Packaging	Memo	0.00							
Packaging									

SB 11/00/03

-inspector to rec
Hand changed Day
Suldoz (40)

11/12/35f

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Page 3

Item ID: D3256-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel

Start Date: 9/30/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/3/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start

Picklist Print

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Page 1

Work Order ID: 74552

Parent Item: D3256-1

Parent Item Name: Panel



Start Date: 9/30/2011

Required Date: 10/3/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-09-28 EC verified by:DD
IPP Rev:b ECN 1052 07-10-31 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA		Purchased		No		100	sf	137.8600	0.987	1.038947			



304/316 .032 Sheet



18140-03

Location

Loc Qty

Loc Code

020

3.3

109057

3.3

MAT020

134.56

117379

31.56

118271

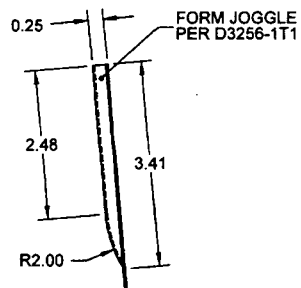
96

118400

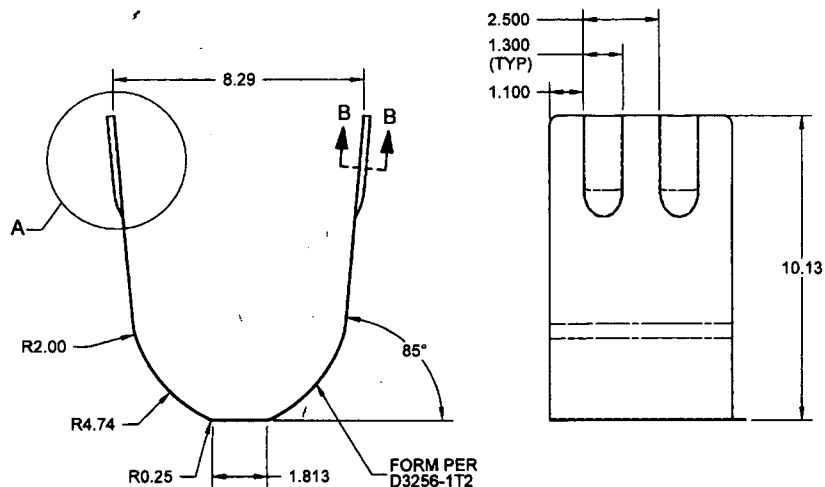
7

117379

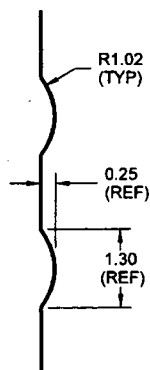
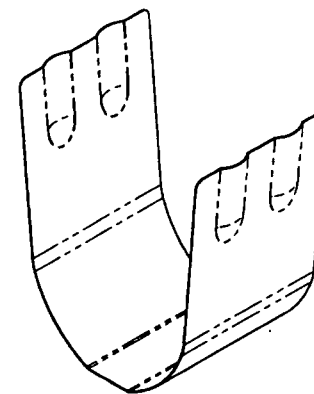
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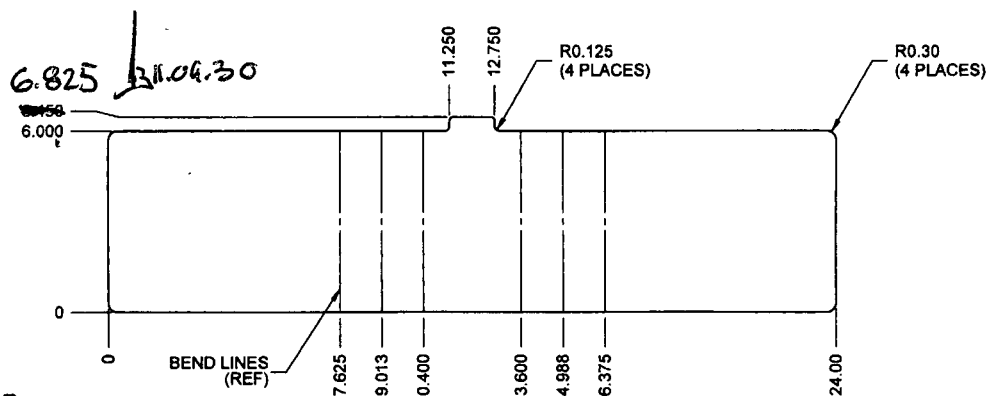
DETAIL A
SCALE 1:2



D3256-1 ACCESS PANEL
(MAKE FROM D3256-1F)



SECTION B-B
SCALE 1:2
(VIEW ROTATED)



D3256-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3256-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.37 lbs

C	D3256-041 ELIMINATED: REMOVED (QTY 22) 0.128 HOLES FROM D3256-1F AND D3256-3 GASKET. INSTRUCTIONS TO DRILL HOLES AND INSTALL D3256-3 GASKET ARE NOW PART OF THE INSTALLATION INSTRUCTIONS	MB	07.09.28
B	D3256-3 DIM 1.30 WAS 0.65	RF	05.06.27
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3256 TITLE ACCESS PANEL SCALE 1:4 <small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
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CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>	DATE 07.09.28	